

Work Order ID 165395

Monday, August 21, 2017 2:55:41 PM

165395

Page 1

Item ID: D4636-7 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Retainer Plate
 Start Date: 9/12/2017 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 9/13/2017 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: AUG 22 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4636	D								
100	FLOW WATER JET	0.07							
100									
Waterjet	Memo	0.24							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>D</u> Prog Rev: <u>D</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.04							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.08							
Quality Control									

(4) 08/17/27

(4) 08/17/27

4 DAS 38 9-89

Monday, August 21, 2017 2:55:41 PM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

4

Cust Item ID:

Start Date: 9/12/2017 **Start Qty:** 4.00

Required Date: 9/13/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number**Insp.
Stamp**

130

Identify as per dwg & Stock Location: St 224

0.00

130

Packaging

Memo

0.04

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.40

Quality Control

4 ^{DAS} 6 ~~AUG 20 2017~~
9-89

17/9/57

U 17.08.24

Picklist Print

Monday, August 21, 2017 2:55:44 PM

Page 1

Work Order ID: 165395

165395

Parent Item: D4636-7

D4636-7

Parent Item Name: Retainer Plate

Start Date: 9/12/2017

Required Date: 9/13/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.04.30 NEW ISSUE DD VERF:EC
13.07.17 AS PER DWG REV.C DD VERF:JLM

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA		Purchased		No		100	sf	117.6350	0.15	0.631579			

M304S22GA

08/17/2017

304/316 .032 Sheet

Location

Loc Qty

Loc Code

MAT020

117.635

m126593

0.975

m134399

22.01

m135192

32.85

m136896

61.8

.7

8 7 6 5 4 3 2 1

D

D

C

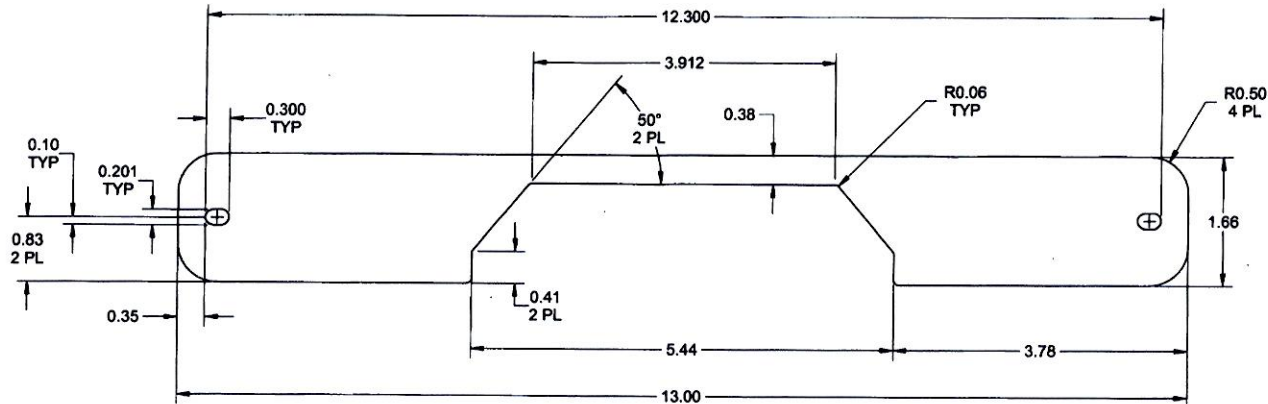
C

B

B

A

A



D4636-7 RETAINER PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 165395 MC

RELEASED
2013-12-23
ASS

170822

NOTES:

- 1) MATERIAL: AISI 303 SS SHEET, ANNEALED 2B FINISH
PER MIL-S-5059 OR ASTM 240 OR ASME SA240
REF DART SPEC M303S22GA
OR AISI 304/316 SS SHEET, ANNEALED 2B FINISH
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM 240 OR ASME SA240
REF DART SPEC M304S22GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.13 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. D
MFG. APPR.	DA	D4636	SHEET 5 OF 7
APPROVED	DA	TITLE	SCALE
DE APPR.	DA	BRACKET ASSEMBLY	NTS
DATE	13.12.09	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1